

Work Order ID 121996

121996

Page 1

July-09-14 10:17:44 AM

Item ID: D4785-117 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 7/09/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/09/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 1407-09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4785	B					2X			Dh 14/12/17

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Pick D4306-1 and drill and chamfer hole as per dwg D4785 using DT9922

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

2x **DAS**
43
8-89 DEC 22 2014

107

Weld per dwg A/R S.S. rod Batch: B128054 0.00

107

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D4785
 2- grind welds flush

2x CC 15-1-9

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121996

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:**Start Qty: 1.00**

*** 1 ***

Customer:

Req'd Qty: 1.00

Reference:

Run Start *NR1*

Stop *NR2*

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

2x

DAS
43
9-89

JAN 08 2015

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

2.

DAS
43
3-89

JAN 08 2015

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

24

DAS
24
9-89

JAN 08 2015

Work Order ID 121996

July-09-14 10:17:44 AM

121996

Page 3

Item ID: D4785-117

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly

Start Date: 7/09/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/09/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 15-01-09
MF 15-01-09

Picklist Print

July-09-14 10:17:47 AM

Page 1

Work Order ID: 121996

121996

Parent Item: D4785-117

D4785-117

Parent Item Name: Rib Assembly

Start Date: 7/09/14

Required Date: 7/09/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.06.21 DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4021-9		Manufactured	No				Each	331.0000		2			
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D4021-9

Bushing

CC 15-1-8

Location

Loc Qty

Loc Code

WA004

331 B122601

107634

22

116010

92

116663

64

117495

97

120334

40

121049

16

D4306-1		Manufactured	No				Each	8.0000					
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D4306-1

Rib

Dh 14/12/17

Location

Loc Qty

Loc Code

WA004

8

121313

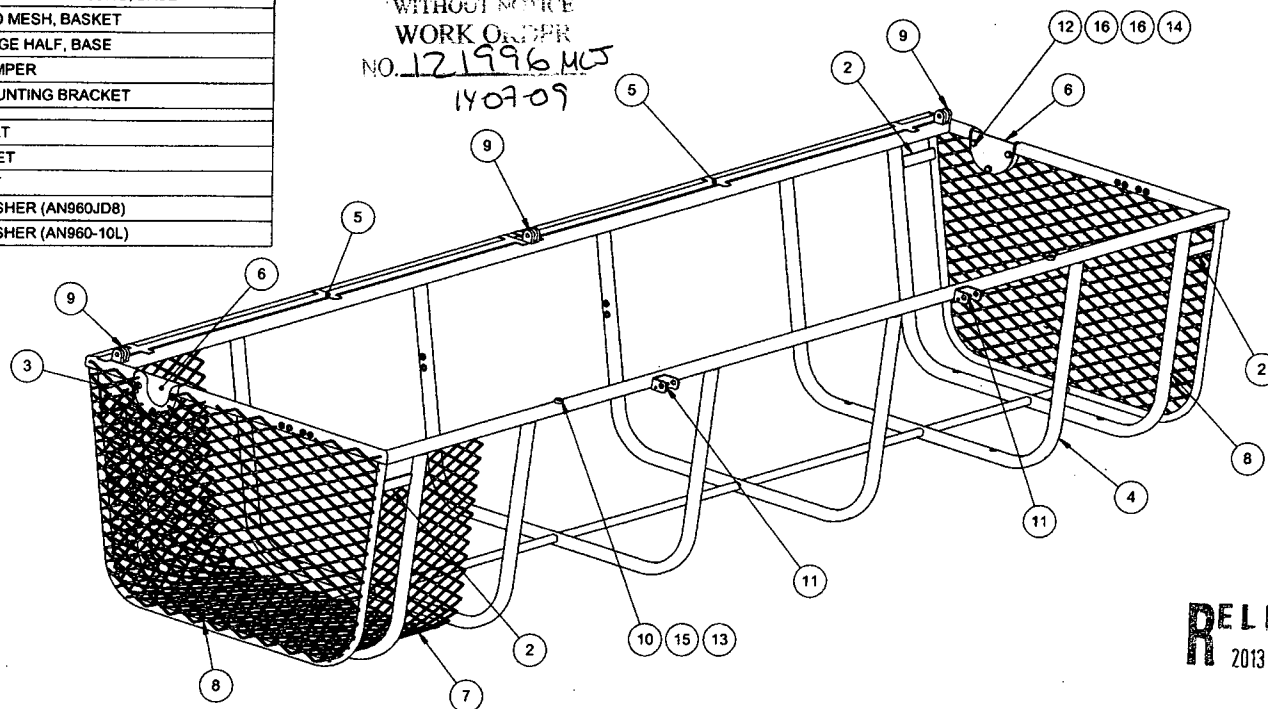
8

117020

2

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121996 MCT
140709



D4785-041 LONG BASKET BASE ASSY, LH/RH

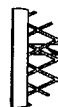
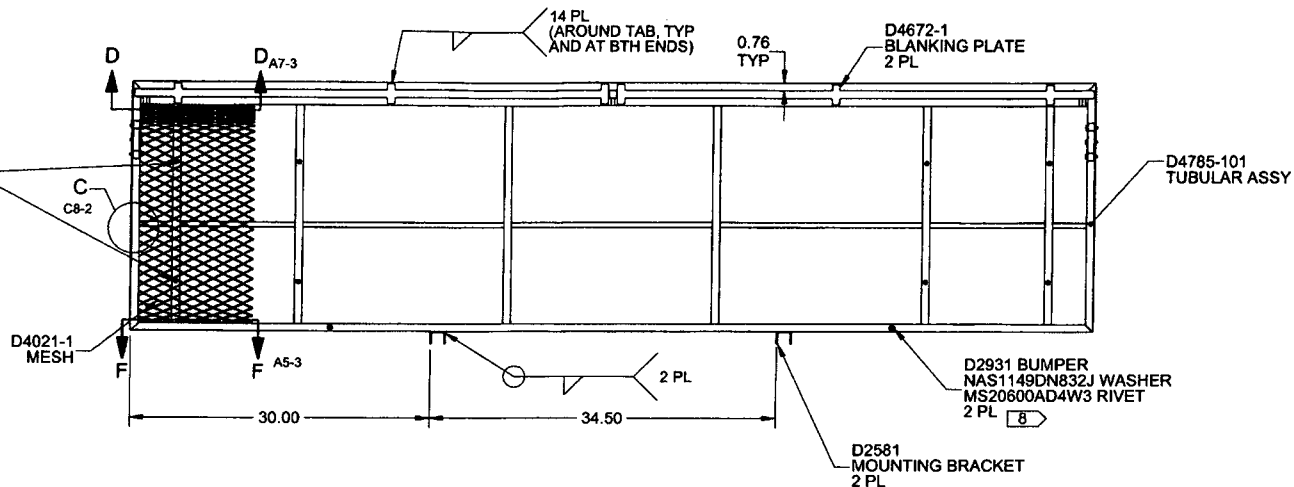
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2013-06-20

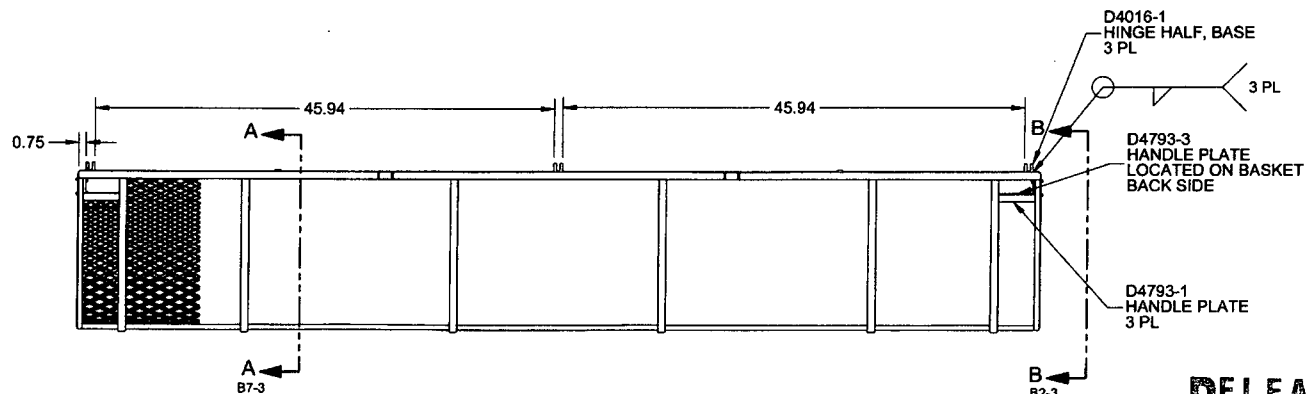
B	REPLACE D3916-S WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4785 TITLE LONG BASKET BASE ASSY COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	RF		
CHECKED	DC		
MFG. APPR.	DS		
APPROVED	JS		
DE APPR.	JS	REV. B SHEET 1 OF 7 SCALE NTS	
DATE	13.06.11		

TRIM MESH LOCALLY
Ø0.50 - Ø0.60
TO CLEAR BUSHINGS
TYP



TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

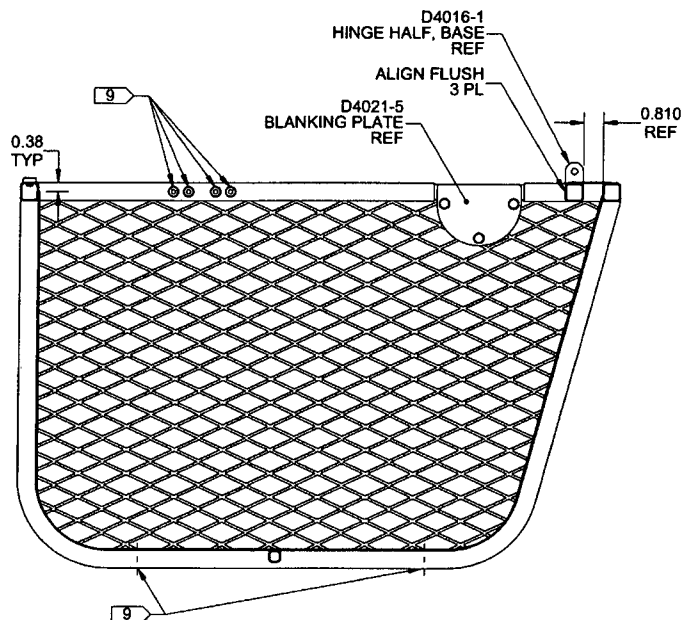
DETAIL C D7-2



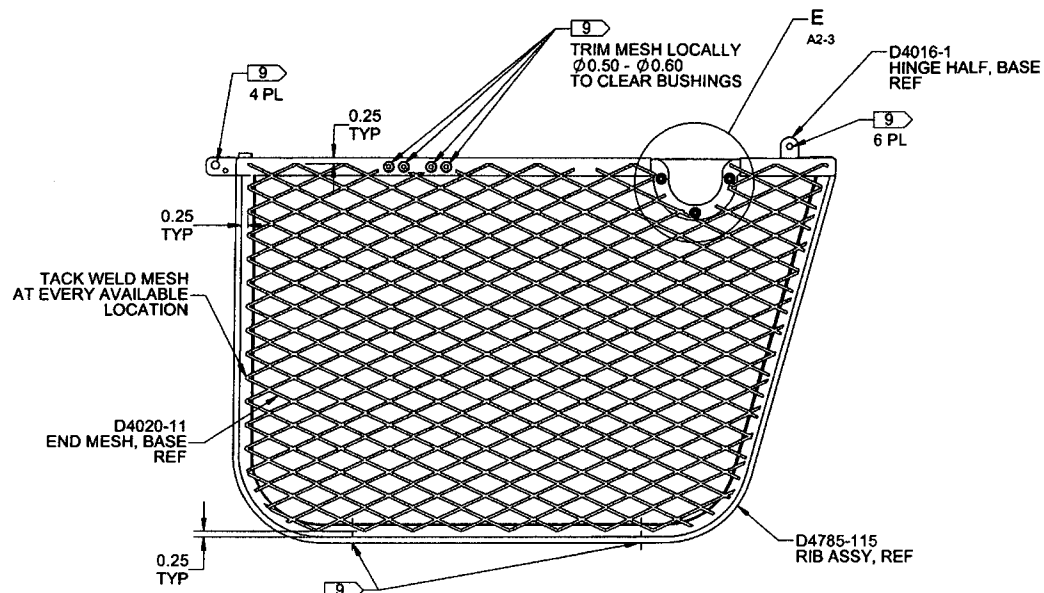
D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

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2013-06-20

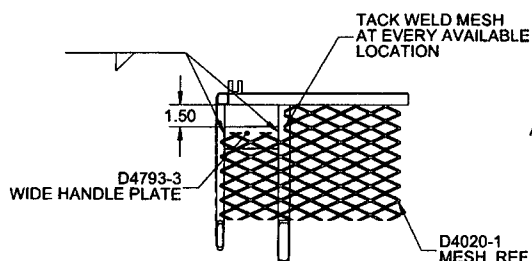
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	MS	D4785	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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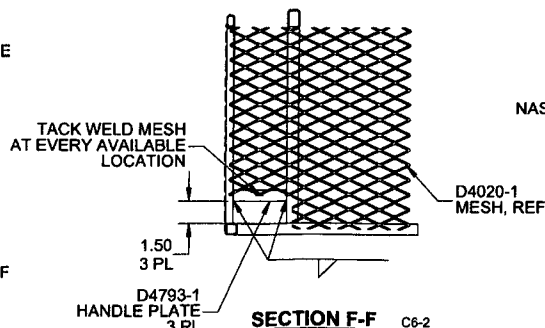
SECTION A-A B7-2



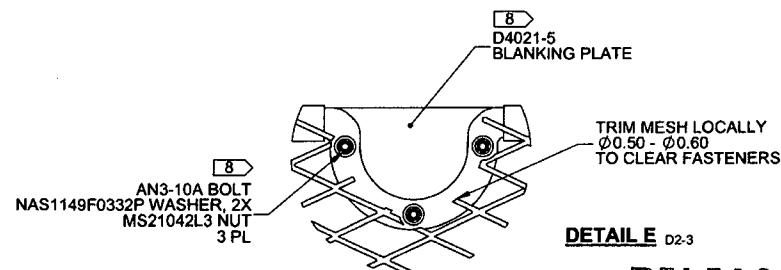
SECTION VIEW B-B A2-2



SECTION D-D D6-2



SECTION F-F C6-2
TYPICAL ON 3 PL

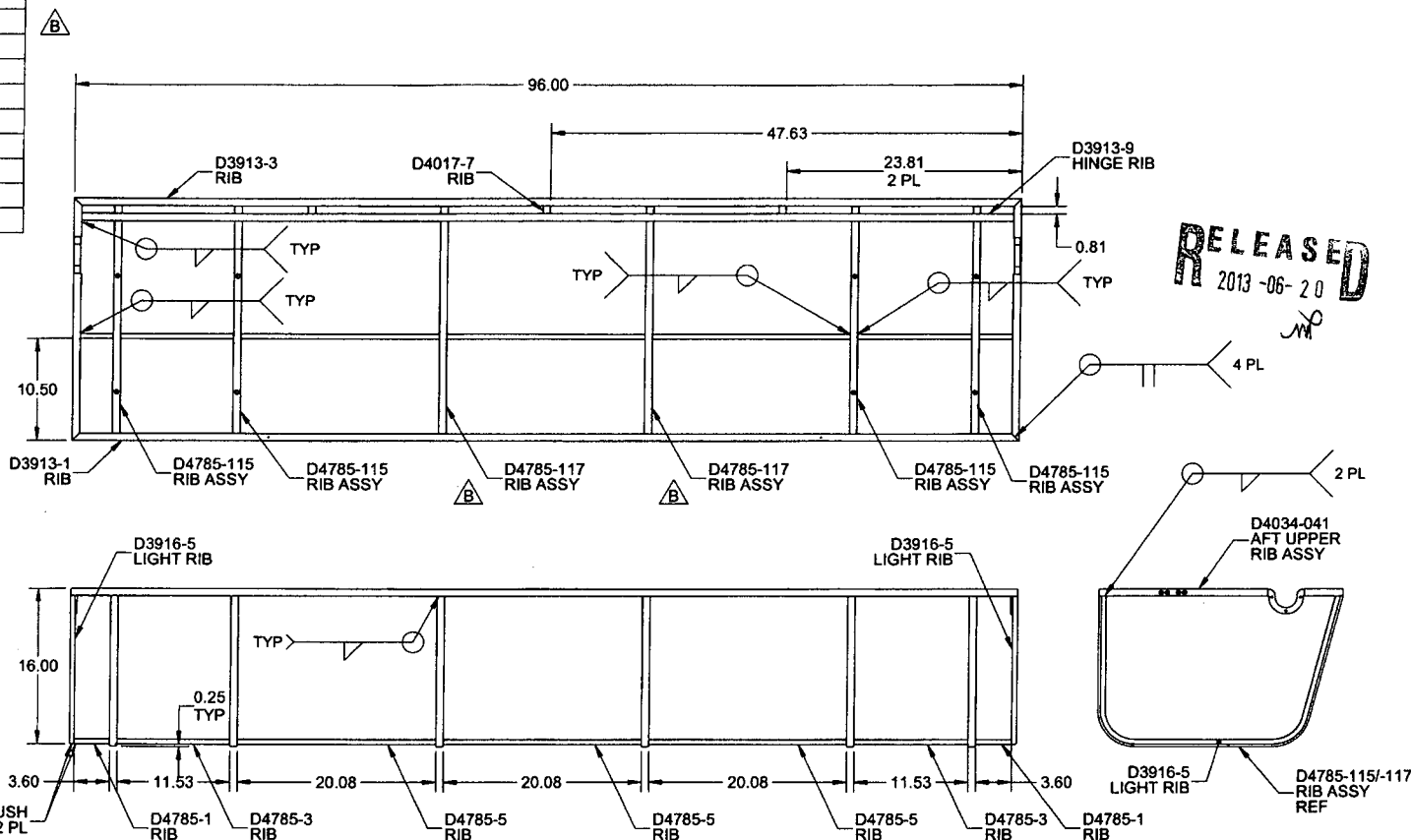


DETAIL E D2-3

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2013-06-20

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	NS	D4785	SHEET 3 OF 7
APPROVED	#	TITLE	SCALE
DE APPR.	#	LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB

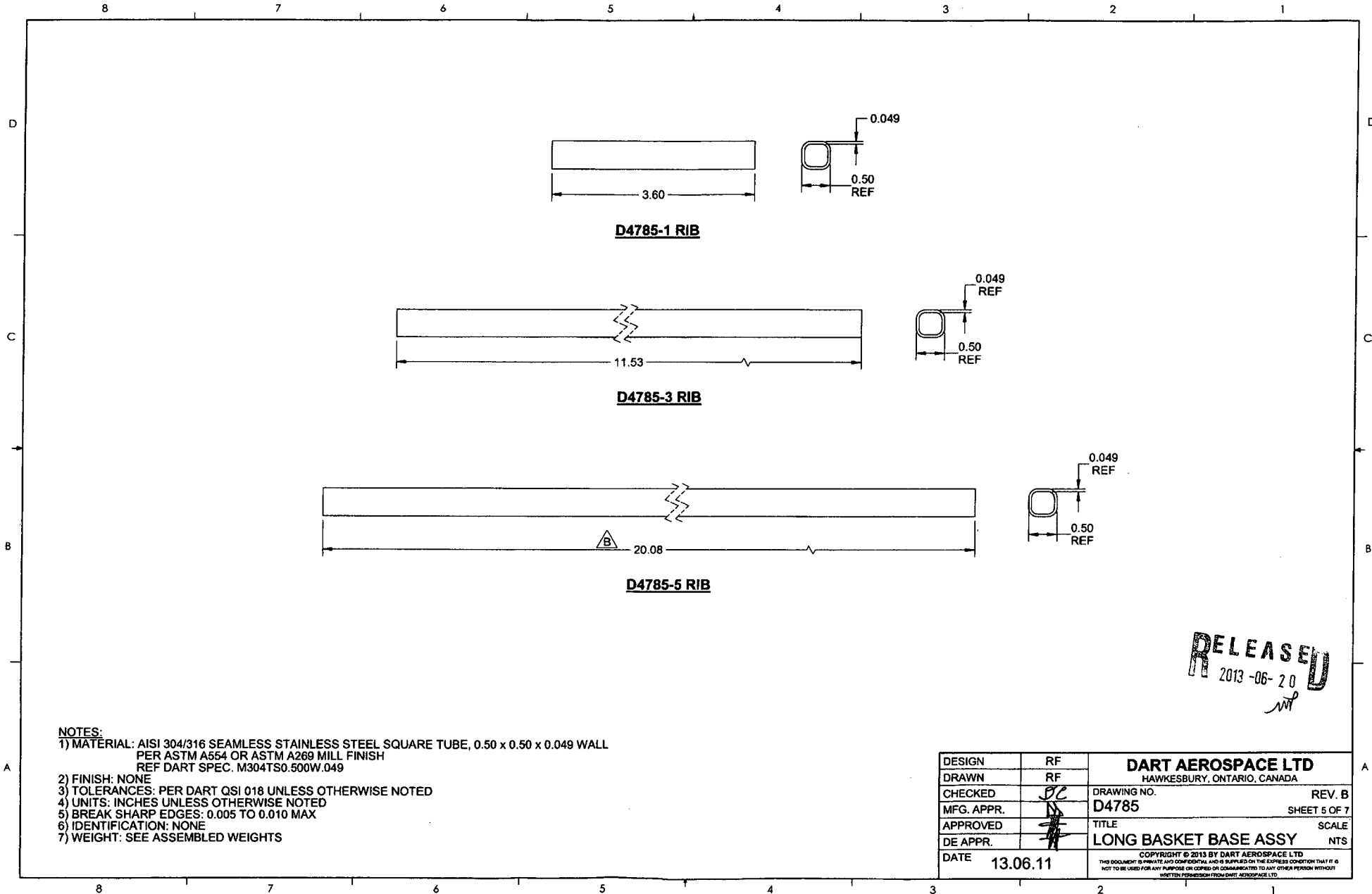


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.65 lbs
- 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.		D4785	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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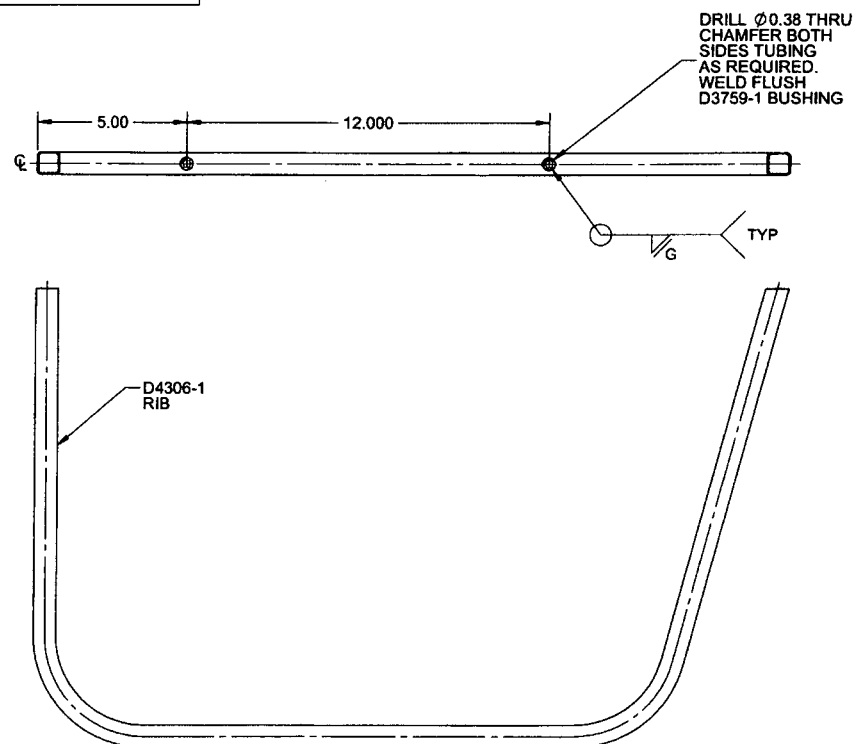


NOTES:
 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
 PER ASTM A554 OR ASTM A269 MILL FINISH
 REF DART SPEC. M304TS0.500W.049
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>SC</i>	DRAWING NO. D4785	REV. B
MFG. APPR.	<i>JS</i>	SHEET 5 OF 7	
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
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ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

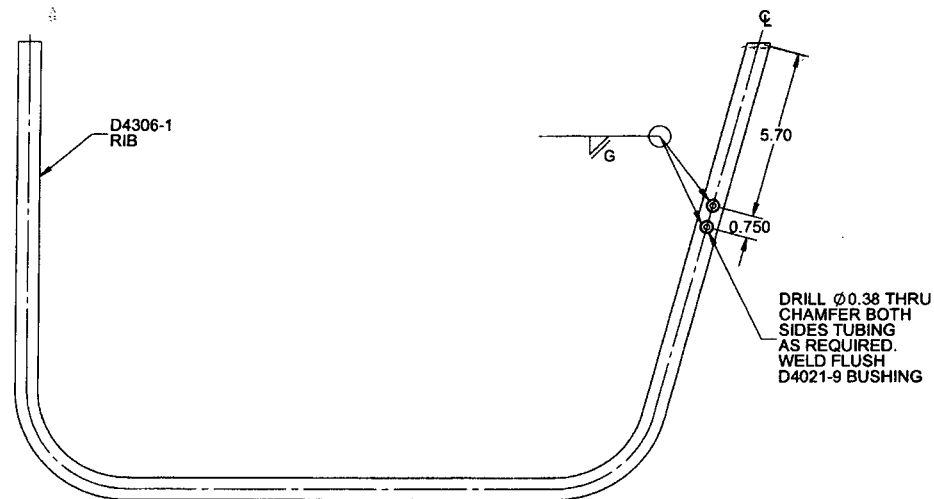
NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO. D4785	REV. B
MFG. APPR.	JS		SHEET 6 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	NTS
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RELEASED
2013-06-20
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ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING



D4785-117 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PC</i>	D4785	SHEET 7 OF 7
APPROVED	<i>PC</i>	TITLE	SCALE
DE APPR.	<i>PC</i>	LONG BASKET BASE ASSY	NTS
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